

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013568**Date Inspected:** 30-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** James Cunningham**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girders**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI observed ABF activities at the Pier 7 location. The QAI noted that the Quality Control (QC) Inspector James Cunningham is present. The QAI inquired with the QC Inspector if there would be any welding today. The QAI was informed that there was no welding planned. The QAI noted that at this time, the shims on OBG segments 5E and 6E have been tack welded onto the bottom plate at the crossbeam intersections. The QAI observed ABF personnel cutting the access holes through the top deck of OBG segment 5E. The QAI observed ABF personnel installing the remaining suspender brackets onto OBG segment 6E with loose fit temporary bolts. The QAI observed other ABF personnel setting grating, lights, ventilation parts, electrical and compressed air utilities into the OBG segments. The QAI noted that these are temporary utilities and will be used during the fabrication of the SAS. The QAI also observed ABF personnel using aerial lifts to access the OBG plate edges and were visibly grinding the primer paint and bevel faces in preparation for the field splice welding. The QAI noted that the deck plate thickness transitions, where visible from the barge decks, appear to be unmodified from the as received condition with an apparent 1/2.5 taper. The QAI attempted to ask the QC Inspector if he was aware of the directions that ABF's Welding Quality Control Manager Jim Bowers had announced earlier this week, that the transitions would be ground to a more shallow taper for the ease of joint and backing bar fit-up during the field splicing operations. The QC Inspector did not make himself available for this question. The QAI noted that this work was in progress until the end of the shift. See the attached photos.

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Summary of Conversations:

The QAI relayed the above mentioned observations to the QAI Lead Bill Levell. There were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi, (916)813-3677, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer